

OK 43.32

Easy-to-weld rutile type electrode for welding in the flat position. The good flowing properties of the weld metal give a good finish of the weld beads both on butt and fillet welds. Good slag detachability. The stable arc, also on low welding currents, makes the electrode very suitable for sheet metal welding.

| Specifications | |
|------------------------|---|
| Classifications | SFA/AWS A5.1 : E6013 EN ISO 2560-A : E 42 0 RR 12 |
| Approvals | ABS : 2 BV : 2 CE : EN 13479 DB : 10.039.36 DNV : 2 LR : 2 UKCA : EN 13479 VdTÜV : 00621 |

Approvals are based on factory location. Please contact ESAB for more information.

| | |
|------------------------|-----------------------|
| Welding Current | AC, DC+- |
| Alloy Type | Carbon Manganese |
| Coating Type | Rutile thick covering |

| Typical Tensile Properties | | | |
|----------------------------|----------------|------------------|------------|
| Condition | Yield Strength | Tensile Strength | Elongation |
| ISO | | | |
| As Welded | 460 MPa | 520 MPa | 27 % |

| Typical Charpy V-Notch Properties | | |
|-----------------------------------|---------------------|--------------|
| Condition | Testing Temperature | Impact Value |
| ISO | | |
| As Welded | 0 °C | 60 J |

Typical Weld Metal Analysis %

| Deposition Data | | | | | |
|-----------------|-----------|---------|----------------|--|-----------------|
| Diameter | Current | Voltage | Efficiency (%) | Fusion time per electrode at 90% I max | Deposition Rate |
| 2.0 x 300.0 mm | 50-80 A | 23 V | 54 % | 36 sec | 0.6 kg/h |
| 2.5 x 350.0 mm | 50-110 A | 25 V | 54 % | 46 sec | 0.9 kg/h |
| 3.2 x 350.0 mm | 80-150 A | 26 V | 57 % | 57 sec | 1.3 kg/h |
| 3.2 x 450.0 mm | 80-140 A | 26 V | 54 % | 74 sec | 1.3 kg/h |
| 4.0 x 350.0 mm | 120-210 A | 25 V | 52 % | 63 sec | 1.6 kg/h |
| 4.0 x 450.0 mm | 120-210 A | 27 V | 54 % | 76 sec | 1.9 kg/h |
| 5.0 x 450.0 mm | 170-290 A | 26 V | 56 % | 87 sec | 2.5 kg/h |
| 6.0 x 450.0 mm | 230-370 A | 31 V | 52 % | 105 sec | 2.8 kg/h |